

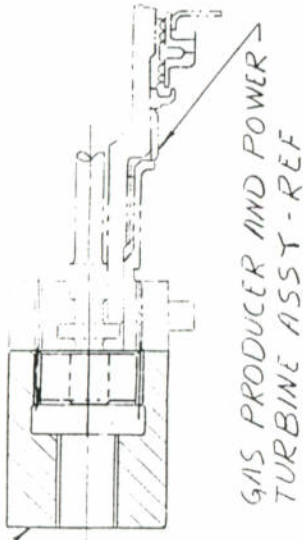
REVISIONS	DESCRIPTION	DATE	APPROVED
X	MICRO-FILMED		

INTERNAL INVOLUTE SPLINE DATA
FLAT ROOT SIDE FIT, CLASS 5

NO. OF TEETH 27
PITCH 32/64
PRESSURE ANGLE 30°
BASE CIRCLE DIA .730709 REF
MINOR DIA .813.816
PITCH DIA .8438
MAJOR DIA .890 MAX
TOOTH TIP BREAK .005 MAX
CIRCULAR SPACE WIDTH .0491-.0518

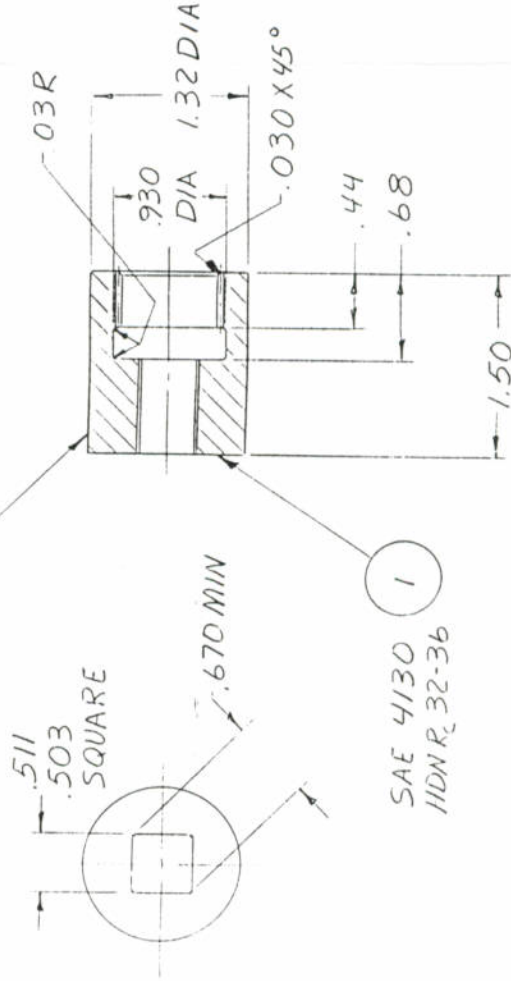
DIMENSION BETWEEN TWO .0540 DIA
PINS = .7670 -.7694

These tool drawings are furnished in accord with the terms of the IDDA Tools Release Agreement. The aperture cards or drawings are to be maintained in the custody of the recipient and shall not be disclosed to any third party without specific written consent of Detroit Diesel Allison Division of GMC.



GAS PRODUCER AND POWER
TURBINE ASSY - REF

ETCH PER NOTE 1



SAE 4130
HIDN R_c 32-36

NOTES:

- MARK AS SPECIFIED IN LOCATION SHOWN WITH 1/8-3/16 HIGH FIGURES THE FOLLOWING:
a) THE NAME "ALLISON" FOLLOWED BY THE TOOL NUMBER AND LAST CHANGE LETTER.
b) VENDOR NAME OR TRADEMARK.
- BLACK OXIDE PER AMS 2485

6893358

DRAWING PRACTICE		APPROVALS		DATE	
SURFACE TEXTURE		DRAWN	W.S. HARTZGEL	NOV 26 '75	
SCREW THREADS		CHECKED	BOCK HITS	JAN 20 '76	
		CH.F. DR.	J.P. HEDIN	JAN 21 '76	
		MET.			
		ENGR. 1	GRISWOLD	DEC 2 '75	
		ENGR. 2			
		ENGR. 3	E. REASEN	DEC 8 '75	
		FINAL	R. HEALY	DEC 8 '75	
		REVIEW APPROVAL			
GENERAL SPECIFICATIONS		SPEC. SUMMARY			
Detroit Diesel Allison Division of General Motors Corporation Indianapolis Operations					
TITLE WRENCH-INSTALLATION AND REMOVAL GAS PRODUCER TURBINE FRONT BRG RETAINING NUT					
MODEL (FIRST USAGE)		APPLICATION: SEE SEPARATE PARTS LIST			
SIZE	CODE IDENT	DWG. No.			
C	73342	6893358			
SCALE FULL		SHEET			

BREAK SHARP EDGES .020 UOS

UNLESS OTHERWISE SPECIFIED		TOL. ON ANGLES = 1°		TOL. ON 3 PLACE DECIMALS = ±.010		TOL. ON 2 PLACE DECIMALS = ±.02	
MATERIAL		SEE ITEM		HEAT TREAT AND HARDNESS		SEE ITEMS	
SURFACE TREAT.		NOTED		INSPECTION			

GEOMETRIC CHARACTERISTIC SYMBOLS		UNLESS OTHERWISE SPECIFIED:	
FLATNESS	PERPENDICULARITY	ALL TRUE POSITION TOLERANCES AND RELATED DATUMS MMC.	
STRAIGHTNESS	PARALLELISM	ALL OTHER FORM AND POSITIONAL TOLERANCES AND RELATED DATUMS RFS.	
ROUNDNESS	ANGULARITY	SEPARATE TRUE POSITION CALLOUTS MAY BE GAGED SEPARATELY REGARDLESS OF DATUM REFERENCE.	
CYLINDRICITY	RUNOUT		
PROFILE OF A LINE	TRUE POSITION		
SURFACE	CONCENTRICITY		
	SYMMETRY		

EACH ITEM PURCHASED SEPARATELY MUST BE STAMPED OR ETCHED WITH TOOL NUMBER AND DETAIL NUMBER IF SUITABLE OR SUFFICIENT AREA NOT AVAILABLE, ATTACH TAG		USED ON ENGINE MODELS 250 SERIES	
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